

## CLAIMS

What is claimed is:

1. A lubricated hot rolling method,  
using a lubricating oil which contains one kind or two  
or more kinds among an high-basic alkaline-earth metal  
phenate, high-basic alkaline-earth metal carboxylate, high-  
basic alkaline-earth salicylate, or high-basic alkaline-  
earth metal sulfonate having a basicity of 40 mgKOH/g or  
higher, and has a viscosity at 40°C of 800 cSt or less, said  
lubricated hot rolling method comprising the step of:

supplying, when a material to be rolled is supplied  
between two rolls, said lubricating oil to said rolls, by  
using a noncombustible gas whose flow rate for one  
lubricating nozzle is 2000 cm<sup>3</sup> or higher per minute, and  
whose flow velocity is 1 m per second or higher, in 0.01 cm<sup>3</sup>  
or more and 20 cm<sup>3</sup> or less per 1 m<sup>2</sup> of surface area of said  
rolls, after said lubricating oil is granulated or atomized  
into particulates having an average size of 1 mm or smaller.

2. The lubricated hot rolling method according to  
claim 1, wherein

the supply of said lubricating oil is started before  
said material to be rolled is bit between said two rolls,  
and an amount supplied of said lubricating oil is 1 m<sup>3</sup> or  
smaller per 1 m<sup>2</sup> of surface area of said rolls.